

Date: Friday, 5/25/2007 8:36:55 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 32649  
Estimate Number : 10288  
P.O. Number :  
This Issue : 5/25/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1/1 Type : SMALL /MED FAB  
Previous Run : 31212  
Written By :  
Checked & Approved By :  
Comment : Est: E 02.09.24 Re-format; Incorporated D2577-101-11 K  
J/RF  
est F 06.09.11 now waterjet EC

Drawing Name : WEARPLATE  
Part Number : D25771  
Drawing Number : D2577 REV E  
Project Number : N/A  
Drawing Revision : E  
Material :  
Due Date : 6/12/2007 Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



B# ~~M10526122~~ M10526122 SAD 07/08/16  
119131 (1)

Comment: Qty: 0.8474 sf(s)/Unit Total: 25.4205 sf(s)

1010/1025/A21/6aA SHEET

B# 104921 (8) SAD 07/10/14

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2577 (D2577-101 detail)

Dwg Rev: E

Prog Rev: E

SAD 07/08/16 (22)

2-Deburr if necessary

SAD 07/06/14 (9)

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/16 SAD 07/06/14 (9)

4.0 QCB

SECOND CHECK



Comment: SECOND CHECK

Er 07/08/16 (22)

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Form joggle as per Dwg D2577 using DT8157

3-Identify as D2577-1

4-Deburr

4- SAD 07/08/20 (22)

SB 07/09/19 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 5/25/2007 8:36:55 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 32649

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/09/19 (x22) counter*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

A/R 7560 Hardcoat Rod

Batch

*M 105686*

*07/09/30 (22)*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07.10.01 (22)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M 104846*

*07-10-02 (22)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*22X 07/10/02*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-18*

*07/10/02*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07.10.03*

Job Completion



*07.10.03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entres

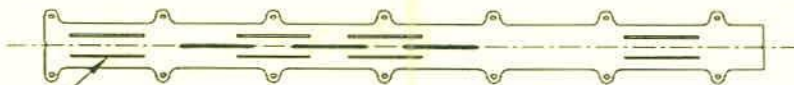




RELEASED  
00 09 26 49

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBROUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



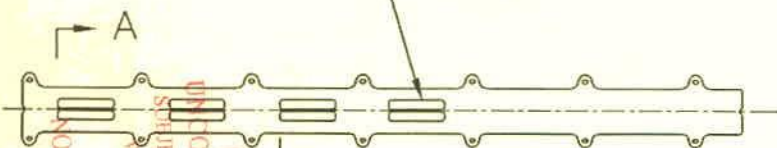
### D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

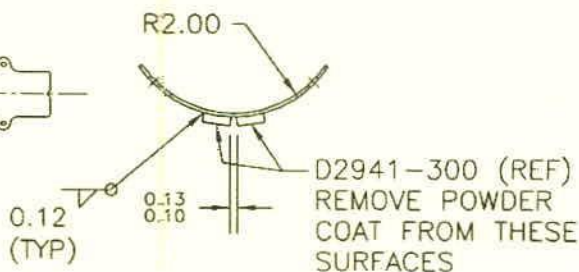
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



1.50 (TYP)  
NO. 32649  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
D2577-101/-11/-13  
INCORPORATE DE09176

SECTION A-A  
SCALE 1:5



### D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

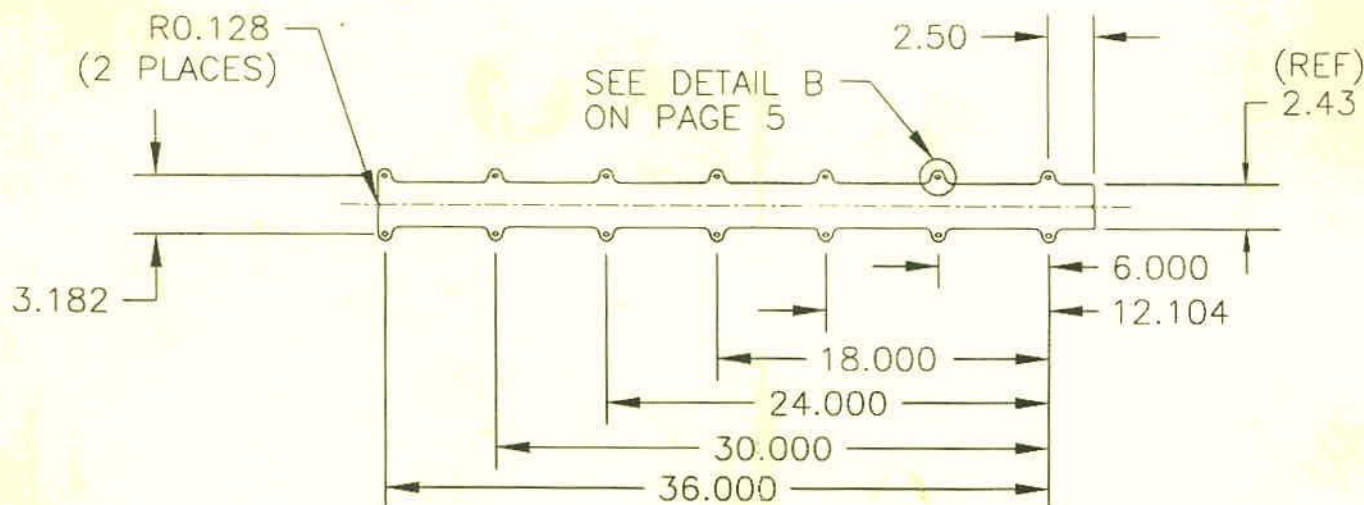
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED







DESIGN	DRAWN BY	DRAWING NO.	REV. E
CHECKED	GP	D2577	SHEET 2 OF 5
DATE	APPROVED	TITLE	SCALE
00.09.22		WEARSHOE	1:10

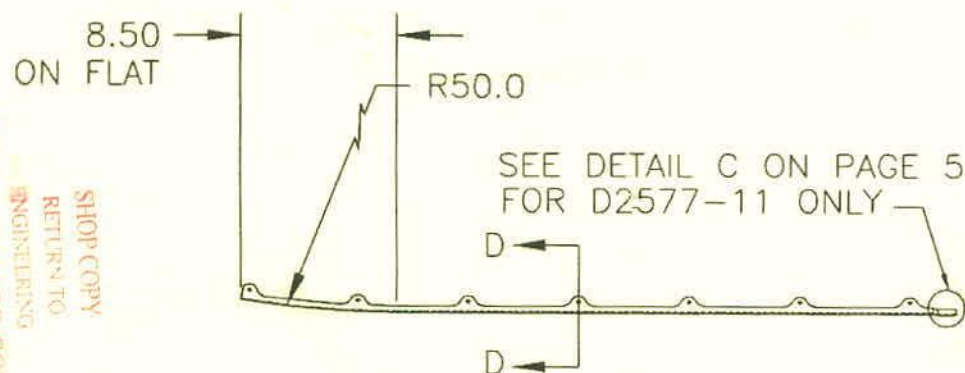


### D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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NO. 32649

### D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
00 09 22 #

THE UNIVERSITY OF CHICAGO PRESS

CHICAGO, ILL.

1963

1963

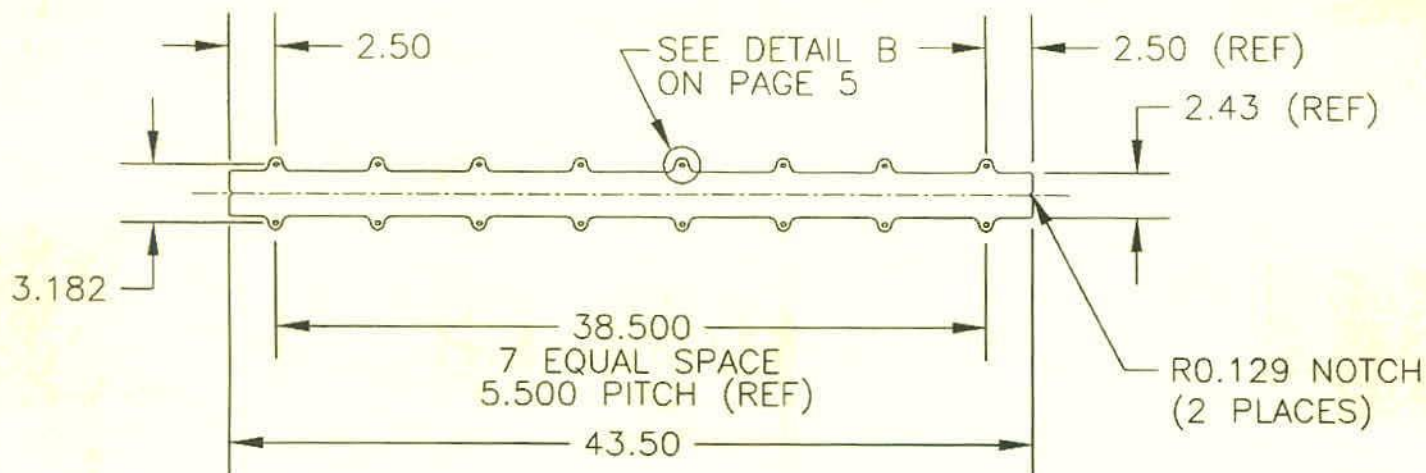
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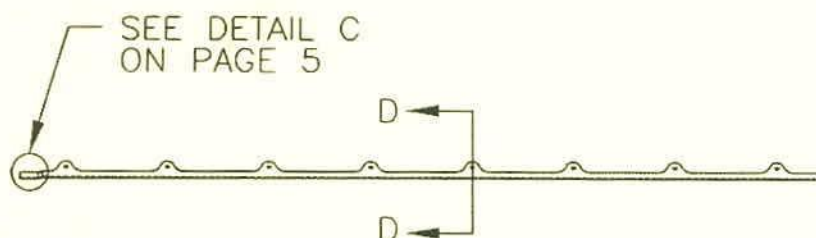
**DART**

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<i>CP</i>	<i>CP</i>	D2577	SHEET 3 OF 5
CHECKED <i>CP</i>	APPROVED <i>CP</i>	TITLE	SCALE
DATE 00.09.22		WEARSHOE	1:10

### D2577-5 FLAT PATTERN



### D2577-5 LONGITUDINAL BEND



### D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

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00.07.26 #

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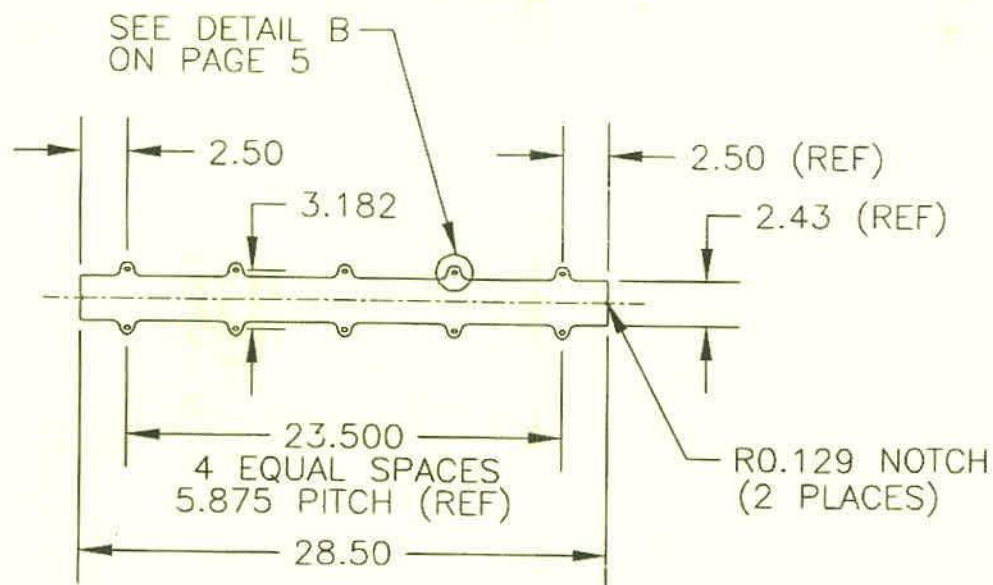
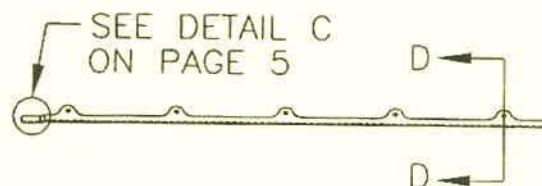
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CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 4 OF 5
		SCALE 1:10

**RELEASED**  
00 09 20 00D2577-7 FLAT PATTERND2577-7 LONGITUDINAL BENDD2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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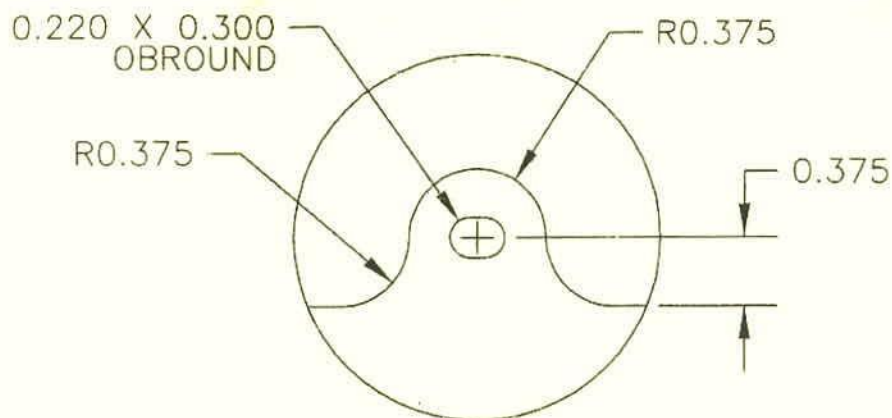




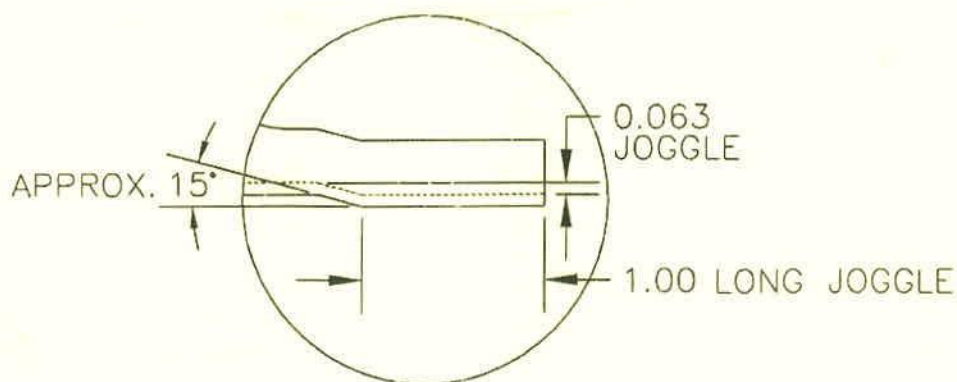
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED  
00.09.22

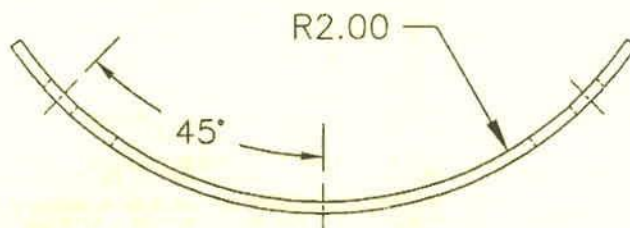
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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DART AEROSPACE LTD		Work Order: 32649
Description: Wear Plate		Part Number: D25771
Inspection Dwg: D2577 Rev: 25		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.182	+/- 0.010	3.190	✓		Vern	
B 36.000	+/- 0.010	36.000	✓		<del>M-T</del> M-T	
C 30.000	+/- 0.010	30.006	✓		M-T	
D 24.000	+/- 0.010	24.000	✓		M-T	
E 18.000	+/- 0.010	18.000	✓		M-T	
F 12.104	+/- 0.010	12.109	✓		Vern	
G 6.000	+/- 0.010	6.006	✓		Vern	
H 2.50	+/- 0.030	2.508	✓		Vern	
I 2.43	+/- 0.030	2.44	✓		Vern	
J 0.220	+/- 0.010	0.221	✓		Vern	
K 0.300	+/- 0.010	0.301	✓		Vern	
L 0.063	+/- 0.010	0.056	✓		Vern	
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAI	Audited by: En	Prototype Approval: N/A
Date: 07/06/14	Date: 07/06/16	Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

